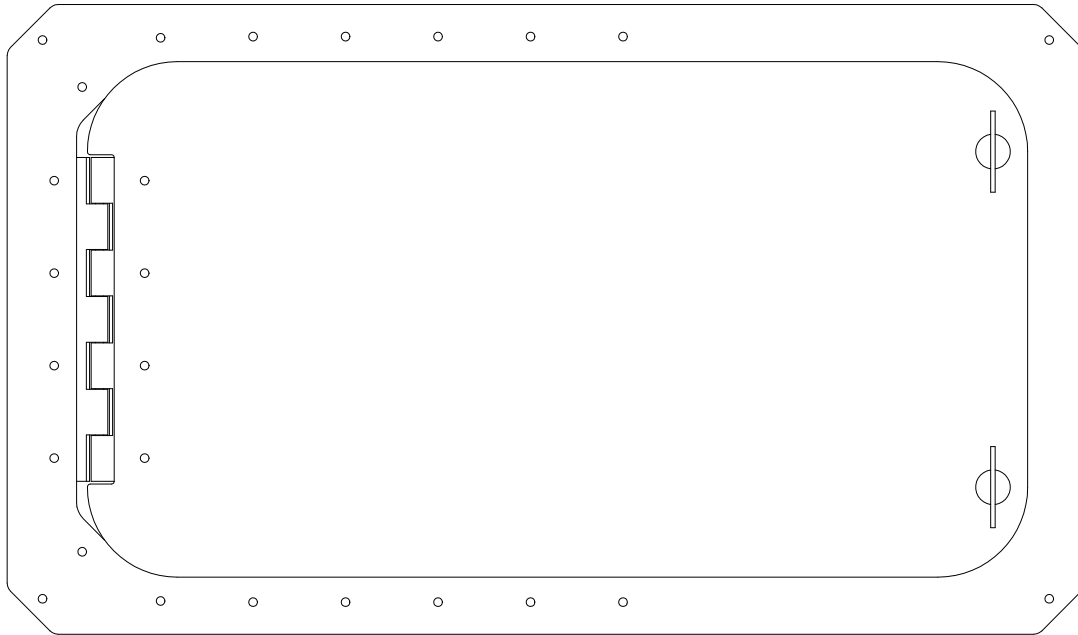




**ALPINE AEROTECH LTD.**  
www.alpineaerotech.com



1260 Industrial Road, Kelowna, B.C., Canada V1Z 1G5  
Phone: (250) 769-6344 Fax: (250) 769-6303  
admin@alpineaerotech.com



## **MAIN SHAFT ACCESS DOOR, KIT INSTALLATION INSTRUCTIONS**

**MODELS: BELL 212**

Read all of the installation instructions thoroughly  
prior to the installation of this product



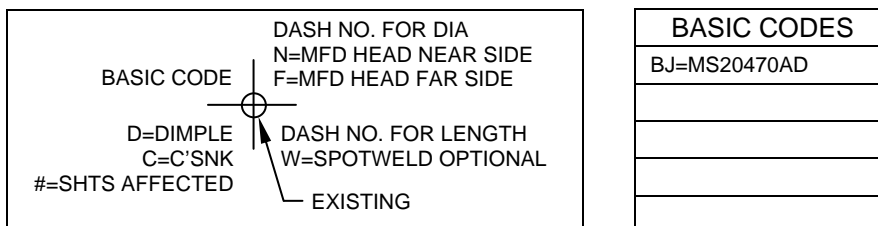
## **Weight & Balance**

<u>Part Number</u>	<u>Description</u>	<u>Weight</u>	<u>Long. Arm</u>	<u>Lat. Arm</u>
AAL-232-010-001	Main Shaft Access Door, Kit	0.28* (lb) 0.12 (Kg)	193.52 (in) 4.92 (m)	0.00 (in) 0.00 (m)

\* Total increase in weight to aircraft.

## **General Notes**

1. All Installation Instructions must be completed in accordance with standard aircraft practices.
2. Refer to the applicable Illustrated Parts Breakdown for the part numbers of the items contained in the Installation Instructions.
3. Refer to the applicable Maintenance Manual Supplement for the inspection and maintenance of the items contained in the Installation Instructions.
4. All Hardware must be torqued to standard aircraft specifications.
5. All Dimensions are in inches.
6. All Rivet Callouts and Rivet Codes are specified as follows.



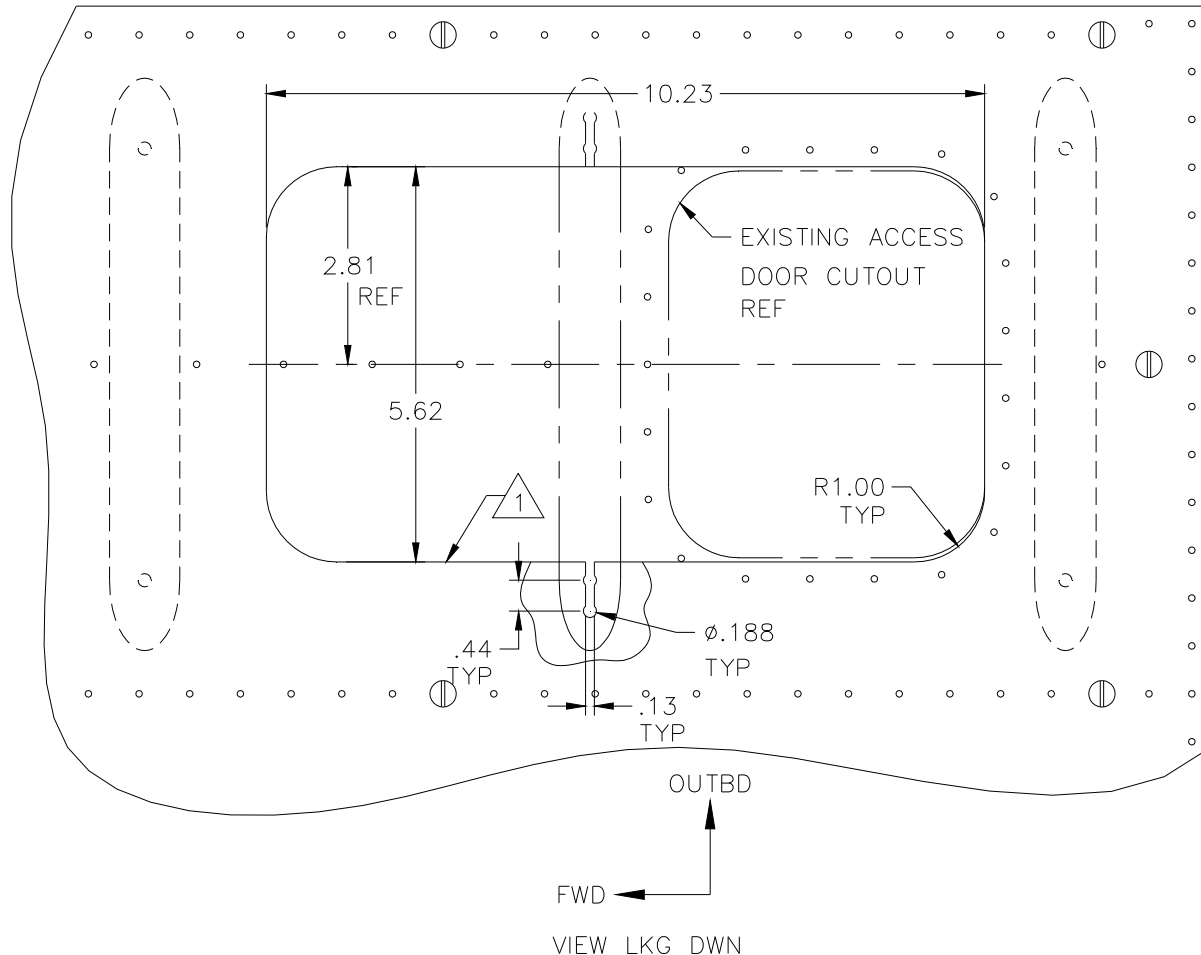
## **Installation Notes**

1. Apply epoxy polyamide, anti-corrosion, primer per MIL-P-2377 on all bare surfaces.
2. Apply polyester, polyurethane, paint per MIL-C-85285 on all exterior surfaces.



## **Installation Instructions**

1. Remove the existing rivets, 21 places, and door/frame assembly, P/N 212-060-822-101, from the cowl, P/N 212-060-803-163. Reference Figure 1.
2. Cut a slot as shown only through the dimpled cowl skin. Flatten the dimple flush with the surrounding skin. Reference Figure 1.
3. While keeping the cowl relatively flat, layout and cut a new hole through the cowl as shown using the existing cutout as a datum. Reference Figure 1.



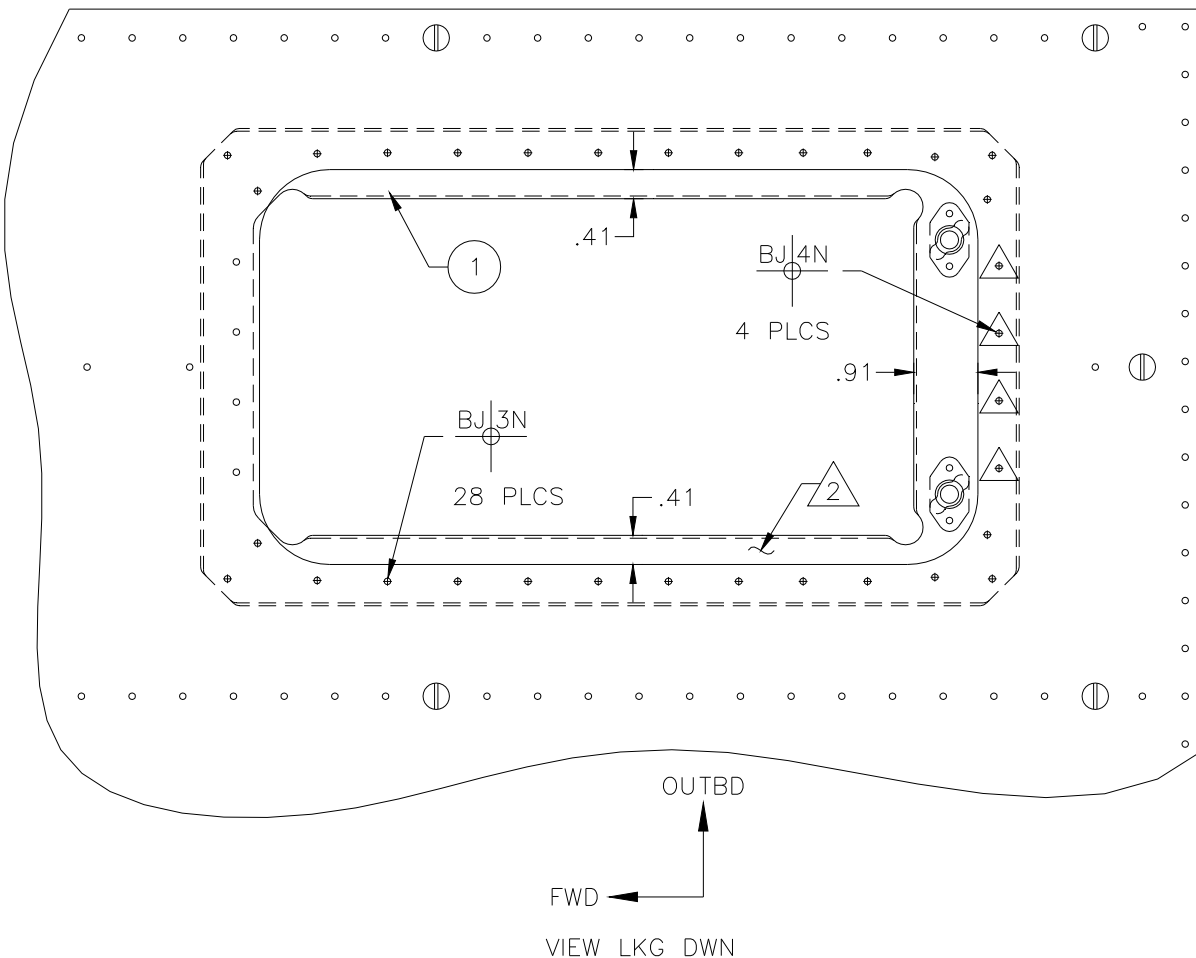
**Figure 1**



## **Installation Instructions**

4. Position the Frame Assembly, Item 1, on the inner side of the cowling as shown. Drill all the existing holes from the cowling into the Frame Assembly. Drill all the holes from in the Frame Assembly into the cowling. Reference Figure 2.
5. Open all the rivet holes as required and rivet the Frame Assembly to the cowling as shown. Reference Figure 2.

**NOTE:** Do not open or rivet the holes for mounting the Door Assembly at this time.

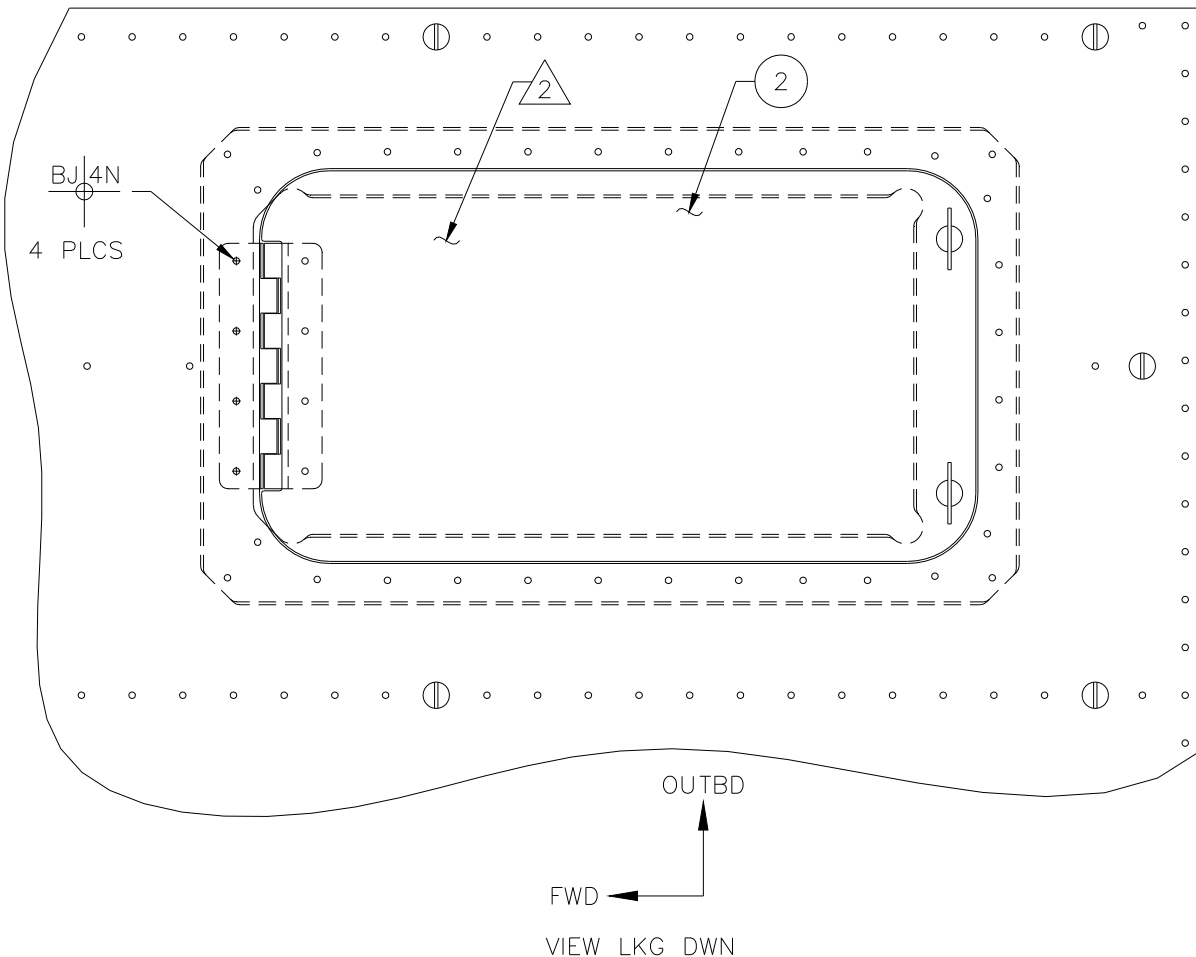


**Figure 2**



## **Installation Instructions**

6. Cleco the Door Assembly, Item 2, on the inner side of the Frame Assembly and check the operation of the door and the location of the door in the cowling cutout. Reference Figure 3.
7. Open the remaining rivet holes in the cowling/Frame Assembly and Door Assembly as required and rivet the Door Assembly to the cowling/Frame Assembly as shown. Reference Figure 3.



**Figure 3**

8. Installation complete.